



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4681-041
Job Sheet 202085



Part No: D4681-041

Job Qty: 4 pcs

Part Name: Web Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/19

Job Tracking No:

Due Date: 11/25/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4681 REV.C SHEETS 1,3 IPP REV:A 13.04.15 NEW ISSUE DD VERF:JLM IPP REV:B 13.08.08 PB1
DD VERF:JLM IPP REV:C 13.11.14 AS PER DWG REV.B DD VERF:JLM IPP REV:D 19.09.19 AS PER DWG
REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	4 pcs	11/25/19		0.00	0.80	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		TF
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 5	4 pcs	11/25/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		TF
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
121	HAAS 4 Axis - B4B	4 pcs	11/25/19		0.18	2.63	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		LLU 2019/10/18



Container No: S225471



Part: D4681-041

Job No: 202085

Serial No/Batch: S225471

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/23/19

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DAS
64
9-89

10/18/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

122 QC 2

4
pcs

11/25/19 0.00 0.00

QC 2 - 1

QC 2 - 12

QC 2 - 14

QC 2 - 17

QC 2 - 19

QC 2 - 2

QC 2 - 20

QC 2 - 22

QC 2 - 23

QC 2 - 25

QC 2 - 32

QC 2 - 33

QC 2 - 35

QC 2 - 39

QC 2 - 4

QC 2 - 40

QC 2 - 44

QC 2 - 45

QC 2 - 48

QC 2 - 49

QC 2 - 50

QC 2 - 51

QC 2 - 52

QC 2 - 57

QC 2 - 62

QC 2 - 63

QC 2 - 8

QC 2 - 66

QC 2 - 64

QC 2 - 65

QC 2 - 5

QC 2 - 71

QC 2 - 73

QC 2 - 69

123 QC 8

4
pcs

11/25/19 0.00 0.00

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

QC 8 - 1 (A)

QC 8 - 47

QC 8 - 40

QC 8 - 52

QC 8 - 23

QC 8 - 57

mu 2019/11/06

DAS
64
988

11-11-08

130 Handfinish - 1-1 Chemical-B4B	4 pcs	11/25/19	0.00 1.12	QC 8 - 76	
				QC 8 - 61	
				Handfinish - 1 - 1 - B4B	BEB19-11-12
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140 QC 7	4 pcs	11/25/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				Plex 10/18/19 10:33 AM	Dart.lajeunesse.mari

					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
					Skidtubes - 1 - B4B	
150 Skidtubes - 2 - B4B	4 pcs	11/25/19	0.00	2.67	Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
160 QC 5	4 pcs	11/25/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170 Packaging 3-1 - Stock - B4B	4 pcs	11/25/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	

10/18/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

180 QC 21 - SA	4 pcs	11/25/19	0.00 0.00	Packaging 3 - 26 - B4B	00
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	DAS 21 NOV 26 2019
				QC 21 - SA - 53	21

Part Op 110 - 1- CUT TO LENGHT AS PER DWG
 Descriptions: 120 - QC5- Inspect part completeness to step on W/O
 121 - (HAAS CNC Vertical Machine), MILL AS PER DWG AND FOLIO FB186 DWG REV: C FOLIO
 REV: MC DEBURR
 122 - (QC2- Inspect parts off machine FAI/FAIB)
 123 - (QC8- Inspect parts - second check)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (QC7-Inspect Chemical Conversion Coat)
 150 - INSTALL DOUBLER BY REVITING AND SEALING FAYING SURFACE WITH PROSEAL AS PER DWG A/R
 PROSEAL: 3229895 exp 1/20
 160 - (QC5- Inspect part completeness to step on W/O)
 170 - (Identify as per dwg & Stock Location: L6002)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2963-125	105 I-Beam Extrusion	4 pcs (1 ea)	110-Skidtubes - 1	B156812
D4681-3	Doubler	8 pcs (2 ea)	150-Skidtubes - 2 - B4B	3202336XU 5727284
MS20470AD4-6	Rivet, Universal Head	356 Ea (89 ea)	150-Skidtubes - 2 - B4B	5166417

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2963-125	4	35	0
150-Skidtubes - 2 - B4B	D4681-3	8	0	0
	MS20470AD4-6	356	1,105	0

Part Specifications

Specifications could not be found.

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QTY -041	P/N	DESCRIPTION
X	D4681-041	WEB ASSY
1	D4681-1	WEB
2	D4681-3	DOUBLER
68	MS20470AD4-6	RIVET, SOLID, PAN HEAD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 7057085 MLS
19-10-18



D4681-3
DOUBLER
B



31.47
REF

D4681-1 WEB

D4681-3
DOUBLER
B

MS20470AD4-6 RIVET
89 PL

D4681-041 WEB ASSY

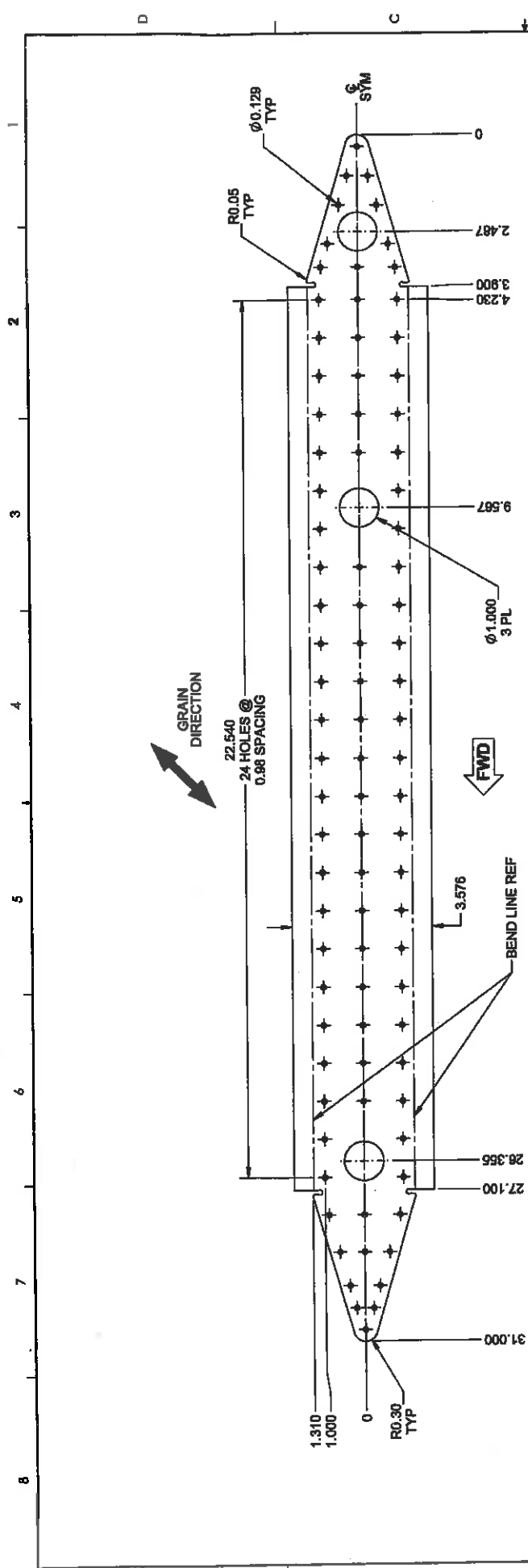
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N 'D4681-041' AND BIN PER QSI 044 METHOD 6.1
 - 7) WEIGHT: 5.92 lbs
 - 8) SEAL FAYING SURFACES WITH PROSEAL P/S 880 B-1/2 (PRC)

RELEASE
2019 SEP 10 NP
ECN 1A-390

APPROVED

REV.	DESCRIPTION	AP	ZF	BY	DATE
C	ADDED -046-6-7 FOR H146, ADDED FWD ARROWS, REMOVED ITEM NUMBERS AND BALLOONS				18.11.21
B	MS20470AD4-6 WAS MS20470AD4-7, ADDED DETAIL A ON SHEET 2, VARIOUS DIMENSIONAL CHANGES.				18.08.08
A	NEW ISSUE				13.02.13
DESIGN	DRAWN	CHECKED	MFG. APPR.	DE APPR.	DATE
DART AEROSPACE USA, INC.					
HILLSBORO, OR					
DRAWING NO. D4681					
TITLE WEB ASSY					
DATE 18.11.21					
SHEET 1 OF 8					
SCALE					
NTS					
THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS TO BE USED FOR THE PURPOSES SPECIFIED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.					





D4681-3F DOUBLER
(FLAT PATTERN)

- NOTES:**
- 1) MATERIAL: 8081-T6/T62 SHEET 0.063 THK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC. M6001T6S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.58 lbs

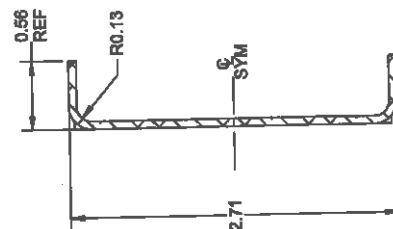
DESIGN	AP	DATE	18.11.21
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	DD		
APPROVED	NO		
DE/APP	DS		

APPROVED

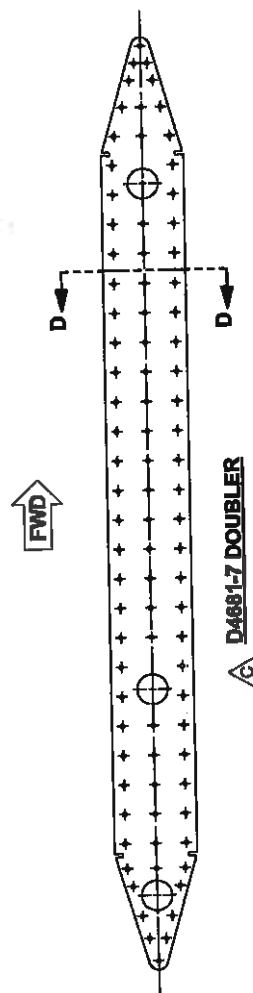
RELEASED

2019 SEP 10 10

DART AEROSPACE USA, INC.	REV. C
HILLSBORO, OR	SHEET 6 OF 8
DRAWING NO. D4681	SCALE
TITLE	NTS
WEB ASSY	
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SECTION D-D
SCALE 4X



D4881-7 DOUBLER

DESIGN	AP	DART AEROSPACE USA, INC. HILLSBORO, OR DRAWING NO. D4681 REV. SHEET 7 OF 8 SCALE 1" = 1"
DRAWN	ZF	
CHECKED	MW	
MFG. APPR.	DD	
APPROVED	NO	
DE APPR.	DS	TITLE WEB ASSY
DATE	18.11.21	CONFIRMED BY DART AEROSPACE USA, INC. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC. NO PARTS OR COMPONENTS THEREOF MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

APPROVED

2019 SEP 10 No
RELEASED

- NOTES:
1) MATERIAL: MAKE FROM D4681-7F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 0119 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.56 lbs



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details: _____